

Work Order ID 69791

Thursday, May 19, 2011 12:31:17 PM

*Ship today*

Page 1

Item ID: D407-802-017

Accept



Setup Start



Revision ID:

Stop



Item Name: Passenger Door Opener Installation, LH

Start Date: 5/19/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 5/19/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: *MP*Date: *11-05-19*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

HIN-D407-802-1

A

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and create labels per PPP D407-802-017 CHG001

5/16/19

105

0.00



Pick Kit

Packaging

Memo

0.00

Packaging

11/15/19

110

0.00



QC4- 100% Inspect kits for completeness

QC

Memo

0.00

Quality Control

*5/14/19**(10)*

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Accept

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Revision ID:

Stop

Item Name: Passenger Door Opener Installation, LH

Start Date: 5/19/2011 Start Qty: 1.00

Cust Item ID:

Required Date: 5/19/2011 Req'd Qty: 1.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

0.00



Packaging

Packaging

Memo

0.00

Identify and pack for shipping as per PPPD407-802-017

Location:

PPP rev: _____

PPPD407-802-017

PPPD407-802-017

130

0.00



QC

QC21- Final Inspection - Work Order Release

Memo

0.00

Quality Control

5/19/11

MF
11-05-19

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Picklist Print

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Work Order ID: 69791

Parent Item: D407-802-017

Parent Item Name: Passenger Door Opener Installation, LH

Start Date: 5/19/2011




Required Date: 5/19/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 10.09.27 new issue DD verf:EC
10.12.03 as per dwg rev.A DD verf:EC

IPP Rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
5 D3552-17  Door Prop		Manufactured	No			105	Each	7.0000	1	1			
				<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>				
				ST272			7						
				64338			7						
8 D3622-5  Ball Stud		Manufactured	No			105	Each	54.0000	1	1			
				<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>				
				ST070			54						
				64330			14						
				64428			20						
				65087			20						
5 D4108-1  Door Doubler, Left		Manufactured	No			105	Each	8.0000	1	1			
				<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>				
				st128			8						
				62301			4						
				64484			4						

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Parent Item: D407-802-017

Parent Item Name: Passenger Door Opener Installation, LH

Start Date: 5/19/2011

Required Date: 5/19/2011

Start Qty: 1.00

Required Qty: 1.00

D4108-049 Manufactured No

105

Each

5.0000

1



Litter Door Fitting Assembly

Location

Loc Qty

Loc Code

ST129

5

62306

1

64490

4

CR3523-4-03

Purchased

No

105

Each

213.0000

21



RIVET

Location

Loc Qty

Loc Code

ST313

213

112991

113

116373

100

MS20426AD4-5

Purchased

No

105

Each

5,782.000

2



Rivet

Location

Loc Qty

Loc Code

MEZZ

493

6733

493

ST317

5289

6874

5289

MS21073L5

Purchased

No

105

Each

147.0000

1



nut plate

Location

Loc Qty

Loc Code

ST302

100

117395

100

ST303

47

113660

27

116583

20

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Shop Packet Print

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Parent Item Name: Passenger Door Opener Installation, LH

Start Date: 5/19/2011

Required Date: 5/19/2011

Start Qty: 1.00

Required Qty: 1.00

MS21209F1-15 Purchased No 105 Each 14.0000 3
HELI COIL

Location Loc Qty Loc Code

ST305 14
104537 14

MS27039C1-06 Purchased No 105 Each 94.0000 3
Screw

Location Loc Qty Loc Code

ST293 94
115768 94

MS27039C1-09 Purchased No 105 Each 139.0000 1
SCREW

Location Loc Qty Loc Code

FP-B 39
17831 39
ST293 100
116290 100

MS27039C1-27 Purchased No 105 Each 47.0000 2
Screw

Location Loc Qty Loc Code

ST293 47
115768 47

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W/O:		WORK ORDER CHANGES					
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Parent Item: D407-802-017

Parent Item Name: Passenger Door Opener Installation, LH

Start Date: 5/19/2011

Required Date: 5/19/2011

Start Qty: 1.00

Required Qty: 1.00

NAS1149C0332R Purchased No

105 Each

3,002.000 2 2



Washer



SP

Location

Loc Qty

Loc Code

ST297

3002

116304

55

117291

2347

117460

600

NAS1149C1165R Purchased No

105 Each

97.0000 2 2



Washer



SP

Location

Loc Qty

Loc Code

ST297

97

115768

97

NAS1149C0532R, Purchased No

105 Each

348.0000 6 6



WASHER



SP

Location

Loc Qty

Loc Code

ST297

348

116289

48

116373

100

116513

200

NAS1149C0563R Purchased No

105 Each

574.0000 6 6



Washer



11/5/11 SP

Location

Loc Qty

Loc Code

ST297

574

112532

100

115768

74

116391

200

117460

200

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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5.3 D407-802-017/-018 Passenger Door Opener Kits

Qty -017	Qty -018	Part Number	Description
		D407-802-017	PASSENGER DOOR OPENER KIT, LH
		D407-802-018	PASSENGER DOOR OPENER KIT, RH
1	1	D3552-17	DOOR PROP
1	1	D3622-5	BALL STUD
1		D4108-1	DOOR DOUBLER, LEFT
	1	D4108-3	DOOR DOUBLER, RIGHT
	1	D4108-5	SMALL RIGHT DOOR DOUBLER
	1	D4108-11	TEMPLATE
	1	D4108-047	SILL DOUBLER ASSEMBLY
1		D4108-049	LITTER DOOR FITTING ASSEMBLY
	19	CR3523-4-2	RIVET
21		CR3523-4-3	RIVET
	4	CR3523-4-4	RIVET
2		MS20426AD4-5	RIVET
	2	MS20426AD4-6	RIVET
1	1	MS21073L5	ANCHOR NUT
3		MS21209-F1-15	HELICOIL
3		MS27039C1-06	SCREW
1		MS27039C1-09	SCREW
2	2	MS27039C1-27	SCREW
2	2	NAS1149C0332R	WASHER
2	2	NAS1149C1165R	WASHER
6	6	NAS1149C0532R	WASHER
6	6	NAS1149C0563R	WASHER

5.4 D407-802-019 Baggage Door Opener Kit, Composite

Qty -019	Part Number	Description
	D407-802-019	BAGGAGE DOOR OPENER KIT, COMPOSITE
1	D3552-19	DOOR PROP
1	D4109-041	DOUBLER ASSEMBLY, BULKHEAD
1	D4109-043	DOUBLER ASSEMBLY
3	80-004-2-6	INSERT
4	MS27039C1-05	SCREW
3	MS27039C1-06	SCREW
7	NAS1149C0363R	WASHER
4	NAS1836-3-08M	INSERT

